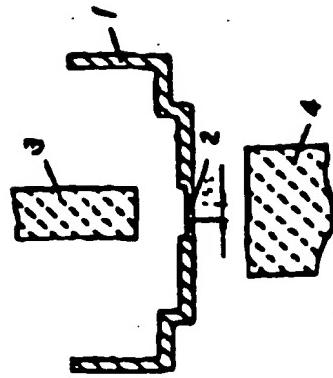
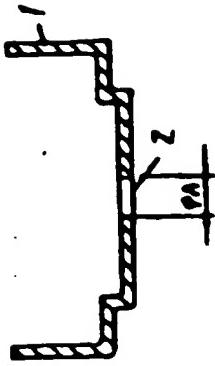


(3)

(54) MANUFACTURE OF BUTTON-SHAPED AIR CELL

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PURPOSE: To provide a manufacture of a small-sized air cell having an outer diameter of 7.9mm or less where an air hole having an inner diameter of 0.15mm or less is formed and performance of the air cell can be enhanced at a low cost in high productivity.

CONSTITUTION: In a first process, a through hole 2 having an inner diameter of 0.6mm is formed at the bottom of a positive electrode case 1. In a second process, the peripheral portion of the through hole 2 is pressed by molds 3, each larger than the through hole 2 having the inner diameter of 0.6mm (each having an outer diameter of 1mm) so that the inner diameter of the through hole 2 is reduced (coining). A button-shaped air cell is constituted of the positive electrode case 1 manufactured in the above processes. The relationship between the inner diameter ϕA of the through hole formed in the first process and the inner diameter ϕB of the through hole formed in the second process expressed by Formula: $\phi A \geq \phi B \times 2$ is optimum for manufacturing the positive electrode case provided with the through hole having an inner diameter of 0.3mm or less.